

Date: Monday, 18/08/2008 3:40:47 PM
User: Julie Lecocq

Process Sheet

Customer : CU-DAR001 Dart Helicopters Services	Drawing Name : EC 135 SKIDTUBE ASSEMBLY
Job Number : 41333	
Estimate Number : 12472	
P.O. Number :	Part Number : D135751011
This Issue : 18/08/2008 S.O. No. :	Drawing Number : D3507 UNDER REVIEW <i>PH 08.10.31</i>
Prsht Rev. : NC	Project Number : N/A
First Issue : / / Type : SKIDTUBES	Drawing Revision : C
Previous Run : 41332	Material :
Written By :	Due Date : 20/09/2008 Qty: 1 Um: Each
Checked & Approved By : <i>JLD 08.8.18</i>	
Comment : Est Rev:A 06-06-21 New Issue JLM Est Rev:B 06-12-18 As per Rev B JLM Est Rev:C 07-12-11 ECN 1036 as per revB DD	

Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
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1.0	DC	DOCUMENT CONTROL
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JLD 08.9.11



Comment: DOCUMENT CONTROL

Photocopy bluefile & type labels per PPP D135-751-011 CHG001 *5 08/10/30*

2.0	D2962150	3.540 Outer Tube, Extrut
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Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)

Pick:

Qty Part Number	Description Batch
1 D2962-150	Extrusion <i>28672</i>

ET 08-08-26

3.0	SKIDTUBES 1	SKIDTUBESS RESOURCE 1
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Comment: LANDING GEAR RESOURCE 1

1-Determine square end of tube and deburr

2-Drill #30 pilot holes using DT8678. Do not open holes.

3- Deburr holes.

ET 08-08-26

4.0	BENDING	BENDING MACHINE - SKIDTUBES
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Comment: BENDING MACHINE

Bend tube as per program on CNC Bender and Dwg D3507. Use 5/16" locator pin on buggy "A". *ET 08-08-28*

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
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Job Number:



Seq. #:

Machine Or Operation:

Description :

5.0

SKIDTUBES 1

SKIDTUBESS RESOURCE 1



Comment: LANDING GEAR RESOURCE 1

1-Cut Fwd end of the tube using DT8185

25 08-08-28

2-Cut Aft end at VC using DT8185

3-Deburr ends

4-Drill Aft & Fwd Cap holes using DT8678

5-Locate DT8870 & Drill Ground wire hole on top of Tube.

6-Locate DT8870 with 3/16 cleco in Ground wire hole, then Pilot Drill all X-Bolt holes using 3/16" drill. ***DO NOT OPEN AFT CAP HOLES*****

7-Drill pilot holes for wearplates using Dt8868, Use DT8892 FOR REAR WEARPLATE HOLES.

8-Open wearplate holes to Ø19/64" (0.297") as per Dwg D3507.

9-Open Aft & Fwd Cap holes using .208" drill.

10-Bore out aft end of tube as per Dwg D3507 & Detail "B".

11-Deburr holes.

P70

25 08-09-08

6.0

QC5

INSPECT WORK TO CURRENT STEP.



Comment: INSPECT WORK TO CURRENT STEP

5 08/10/09

7.0

HAND FINISHING1

HAND FINISHING RESOURCE #1



Comment: HAND FINISHING RESOURCE #1

Chemical Conversion Coat as per QSI 005 4.1

D 14 8-10-14

8.0

QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION

25 08-10-14

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: D135-751-011 PAR #: NA Fault Category: Prod/Skid tube NCR: (Yes) No DQA: D Date: 08/10/13
 QA: N/C Closed: AG Date: 08/11/04

NCR: <u>41333</u>		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			
06-10-09	5.0	Employee used the holes off of the wear plate drilling DT886B. Holes are to be drilled using DT8892 R.C. Under review & some changes LACK of attention	<u>BS142</u>	Drill the 6 aft wear plate holes with weld, and grind flush & A/R M109213 Re-drill as per new approved jig DT8892 in progress.	<u>BS</u> 08/10/10 <u>BS</u> 08/10/09	<u>S</u> <u>06/10/09</u>	<u>BS142</u>	<u>06/10-09</u>

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Job Number: 41333

Part Number: D135751011

Job Number:



Seq. #:

Machine Or Operation:

Description :

9.0

D35043

Crossbolt Spacer



Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)

CROSSBOLT SPACER

Batch: B 31232

BE 08/10/21

10.0

D35041

Crossbolt Spacer



Comment: Qty.: 2.0000 Each(s)/Unit Total : 2.0000 Each(s)

CROSSBOLT SPACER

Batch: B 31234

BE 08/10/21

11.0

D35051

Web



Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)

WEB

Batch: 42531

2C 08-10-16

12.0

D35061

Doubler



Comment: Qty.: 4.0000 Each(s)/Unit Total : 4.0000 Each(s)

DOUBLER

Batch: B 41605

Jb 8-10-22

13.0

D35063

Doubler



Comment: Qty.: 2.0000 Each(s)/Unit Total : 2.0000 Each(s)

DOUBLER

Batch: B 28964

Jb 8-10-22

14.0

D35045

Crossbolt Spacer



Comment: Qty.: 2.0000 Each(s)/Unit Total : 2.0000 Each(s)

CROSSBOLT SPACER

batch: B 36181

BE 08/10/21

15.0

MS20601AD4W3

Rivet



Comment: Qty.: 12.0000 Each(s)/Unit Total : 12.0000 Each(s)

Rivet

Batch: 107823

Jb 8-10-22

Dart Aerospace Ltd

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Part Number: D135751011

Job Number:



Seq. #:

Machine Or Operation:

Description :

16.0

SKIDTUBES 1

SKIDTUBESS RESOURCE 1



Comment: LANDING GEAR RESOURCE 1

1-Open X-Bolt holes to .375"(2Places) & .500"(2Places) as per Dwg D3507. and Detail "F"

2-Counter Sink X-BOLT holes as per Dwg D3507

3-Deburr and blow out chips from inside of tube.

4-Bond web as per Dwg D3507 & QSI 015

A/R 241 Sike Flex Batch: 109338

Exp Date: 8-11-01

8T 08-10-16

5-Weld x-bolt (D3504-1/-3) spacers as per Dwg D3507 and Detail C-C & D-D.

A/R AL ROD Batch: m109213

BE 08-10-21

6-Grind welds flush

7-Drill Rivet Holes as per Dwg D3507 Using Dt8871A&B

8-Deburr Rivet holes.

25 08-10-15

JD 8-10-22

Tools: E

17.0

QC10

VISUAL INSPECTION OF GROUND WELDS



Comment: VISUAL INSPECTION OF GROUND WELDS

SOB 10/22 (+)

18.0

SKIDTUBES 1

SKIDTUBESS RESOURCE 1



Comment: LANDING GEAR RESOURCE 1

1-Rivet D3506-1/-3 as per Dwg D3507.

JD 8-10-22

19.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

SOB 10/22 (+)

Dart Aerospace Ltd

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DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

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Job Number: 41333

Part Number: D135751011

Job Number:



Seq. #:

Machine Or Operation:

Description :

20.0

HAND FINISHING1

HAND FINISHING RESOURCE #1



(1X)

Comment: HAND FINISHING RESOURCE #1

Pressure wash as per QSI 005

M-1

08/10/25

21.0

POWDER COATING

POWDER COATING



(1X)

Comment: POWDER COATING

Powder Coat White Gloss (Ref: 4.3.5.1) as per QSI 005 4.3

START TIME:

OVEN TEMPERATURE:

FINISH TIME:

1:00
3200F
1:30

M-1

08/10/25

22.0

QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION

08-10-27

(X)

23.0

ALS71032130

Insert



Comment: Qty.: 38.0000 Each(s)/Unit Total: 38.0000 Each(s)

Insert

Batch:

5414
M 109431

24.0

ALS41032225

Insert



Comment: Qty.: 1.0000 Each(s)/Unit Total: 1.0000 Each(s)

Insert

Batch:

M 100621

25.0

HAND FINISHING1

HAND FINISHING RESOURCE #1



Comment: HAND FINISHING RESOURCE #1

Install Wearplate & Ground Wire inserts as per Dwg D3507.

90

08-10-27

(X)

26.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

Inspect Inserts

S

08/10/27

(X)

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

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Drawing Name: EC 135 SKIDTUBE ASSEMBLY

Job Number: 41333

Part Number: D135751011

Job Number:



Seq. #:

Machine Or Operation:

Description :

27.0

AN526C1032R10

Screw



Comment: Qty.: 2.0000 Each(s)/Unit Total : 2.0000 Each(s)
Screw
batch M108062 *je*

28.0

D29653

Cap



Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)
Cap
Batch: B29993 *je*

29.0

D2965

Cap, 105 Skidtube



Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)
Cap
Batch: B341523 *je*

30.0

D35081

Wearplate



Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)
WEARPLATE
Batch: B331195 *je*

31.0

D35083

Wearplate



Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)
WEARPLATE
Batch: B338527 *je*

32.0

D35085

Wearplate



Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)
WEARPLATE
Batch: B331197 *je*

33.0

D35087

Wearplate



Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)
WEARPLATE
Batch: B336179 *je*

08-10-27

je

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
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Job Number: 41333

Part Number: D135751011

Job Number:



Seq. #:

Machine Or Operation:

Description :

34.0

D35581

Gasket



Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)

GASKET

Batch: B29998

jd

35.0

D35583

Gasket



Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)

GASKET

Batch: B42253

jd

36.0

D35585

Gasket



Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)

GASKET

Batch: B3000

jd

37.0

D35587

Gasket



Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)

GASKET

Batch: B36388

jd

38.0

D3492041

Plug Assembly



Comment: Qty.: 4.0000 Each(s)/Unit Total : 4.0000 Each(s)

PLUG ASSEMBLY

Batch: B42182

jd

39.0

D3492043

Plug Assembly



Comment: Qty.: 4.0000 Each(s)/Unit Total : 4.0000 Each(s)

PLUG ASSEMBLY

batch: B41138

jd

40.0

D3492047

Plug Assembly



Comment: Qty.: 2.0000 Each(s)/Unit Total : 2.0000 Each(s)

PLUG ASSEMBLY

Batch: B325961

jd

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

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Drawing Name: EC 135 SKIDTUBE ASSEMBLY

Job Number: 41333

Part Number: D135751011

Job Number:



Seq. #:

Machine Or Operation:

Description :

41.0

AN960C10L

washer



Comment: Qty.: 33.0000 Each(s)/Unit Total : 33.0000 Each(s)

Washer

Batch: M1109282

Handwritten signature

42.0

AN3C4A

BOLT



Comment: Qty.: 31.0000 Each(s)/Unit Total : 31.0000 Each(s)

BOLT

Batch: M1109431

Handwritten signature

43.0

AN3C5A

Bolt



Comment: Qty.: 2.0000 Each(s)/Unit Total : 2.0000 Each(s)

Bolt

Batch: M1108928

Handwritten signature

44.0

HAND FINISHING1

HAND FINISHING RESOURCE #1



Comment: HAND FINISHING RESOURCE #1

✓ 1-Inspect for Foreign objects

2-Install Fwd & Aft caps as per Dwg D3507 And Detail "A" & "B"

✓ A/R 241 Sika Flex Batch: M1109449
Exp Date: 08/11

✓ 3-Install Wearplates as per Dwg D3507 ,

Note: Install (1) Bolt and (1) washer on Ground Wire insert on top of tube

Do not Install Scews where indicated on Dwg(Note #6)

✓ A/R 241 Sika Flex Batch: M1109449
Exp Date: 08/11

✓ 4-Install Plug assemblies as per Dwg D3507.

A3507

5- Wing Walk as per Dwg D3043 and QSI 005 4.4

M1109219

Handwritten signature
08-10-22 (X)

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____
 QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
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Job Number: 41333

Part Number: D135751011

Job Number:



Seq. #:

Machine Or Operation:

Description :

45.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

S 08/10/28 (X)

46.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1
Pick Packing Kit

47.0

D35121

Wearplate



Comment: Qty.: 2.0000 Each(s)/Unit Total: 2.0000 Each(s)
WEARPLATE
Batch: 334510360

SS 08/10/28 (X)

48.0

AN960JD10L

Washer



Comment: Qty.: 8.0000 Each(s)/Unit Total: 8.0000 Each(s)
Washer
Batch: M105793

SS 08/10/28 (X)

49.0

AN3C4A

BOLT



Comment: Qty.: 8.0000 Each(s)/Unit Total: 8.0000 Each(s)
BOLT
BATCH: M108599

Batch not in comp SS 08/10/28 (X)

50.0

QC4

INSPECT 100% KITS FOR COMPLETENESS



Comment: INSPECT 100% KITS FOR COMPLETENESS

S 08/10/30 (X)

51.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1
Identify and pack for shipping as per PPP D135-751-011
Location: _____
PPP Rev: _____

Rev B

SS 08/10/29 (X)

341333

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

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Job Number:



Seq. #:

Machine Or Operation:

Description :

52.0

QC21

FINAL INSPECTION/W/O RELEASE



08/10/31 *[Signature]*

Comment: FINAL INSPECTION/W/O RELEASE

Job Completion



MF 08-10-30

Dart Aerospace Ltd

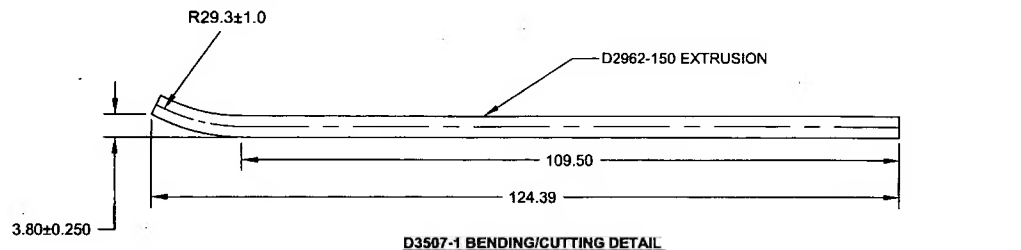
W/O:		WORK ORDER CHANGES					
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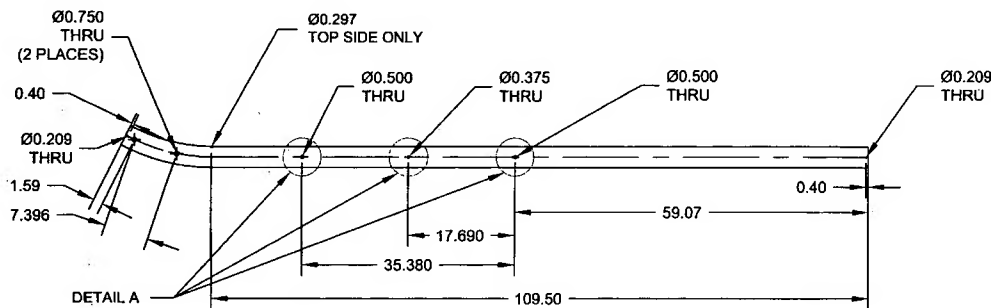
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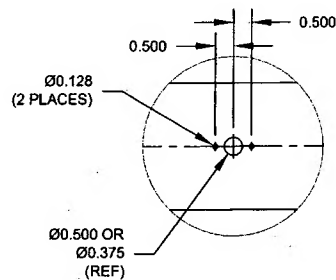
NOTE: Date & initial all entries



D3507-1 BENDING/CUTTING DETAIL



D3507-1 DRILLING DETAIL



DETAIL A
(TYP, 6 PLACES)
SCALE 3:10

Qty	Part Number	Description
X	D3607-041	SKIDTUBE ASSEMBLY
1	D2962-150	EXTRUSION
1	D2965	CAP
1	D2965-3	CAP
4	D3492-041	PLUG ASSEMBLY
4	D3492-043	PLUG ASSEMBLY
2	D3492-047	PLUG ASSEMBLY
2	D3504-1	CROSS BOLT SPACER
1	D3504-3	CROSS BOLT SPACER
2	D3504-5	CROSS BOLT SPACER
1	D3505-1	WEB
4	D3506-1	DOUBLER
2	D3506-3	DOUBLER
1	D3508-1	WEARPLATE
1	D3508-3	WEARPLATE
1	D3508-5	WEARPLATE
1	D3508-7	WEARPLATE
1	D3558-1	GASKET
1	D3558-3	GASKET
1	D3558-5	GASKET
1	D3558-7	GASKET
38	AELS-1032-130	INSERT
1	AELS-1032-225	INSERT
31	AN3C4A	BOLT
2	AN3C5A	BOLT
2	AN526C1032-10	SCREW
33	AN960C10L	WASHER
12	MS20601AD4W3	RIVET

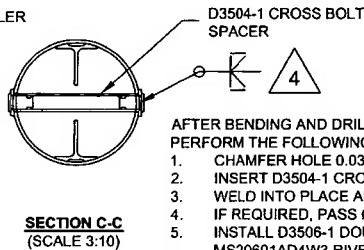
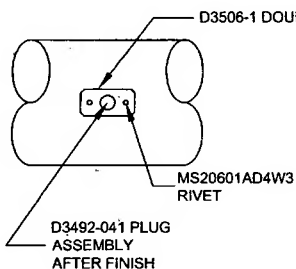
GENERAL NOTES:

- 1) FINISH:
CHEMICAL CONVERSION COAT PER DART QSI 005 4.1 PRIOR TO INSERTING D3505-1 WEB. POWDER COAT ASSEMBLY GLOSS WHITE (REF 4.3.5.1) PER DART QSI 005 4.3. ANTI-SKID PAINT AS INDICATED TO 1.00 ABOVE CENTER LINE PER DART QSI 005 4.4
- 2) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 3) DIMENSIONS: INCHES UNLESS OTHERWISE NOTED
- 4) WELDING TO BE DONE PER DART QSI 004
- 5) INSERT D3505-1 WEB TO LOCATION SHOWN OFF AFT END OF SKIDTUBE AND BOND WEB INTO OUTER TUBE WITH NON-STRUCTURAL SIKAFLEX-241/-291 ADHESIVE PER DART QSI 015 AFTER BENDING
- 6) USE DART DRILL TEMPLATE DT8868 TO LOCATE AND DRILL Ø0.297 HOLES (38 PLACES) FOR WEARSHOE INSERTS. INSTALL AELS-1032-130 PER SECTION C-C (38 PLACES) AFTER FINISH. SEAL WEARPLATE BOLTS WITH SIKAFLEX-241/-291.
- 7) DO NOT INSTALL AN3C4A BOLTS AND AN960C10L WASHERS IN INDICATED LOCATIONS

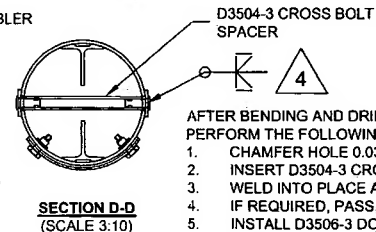
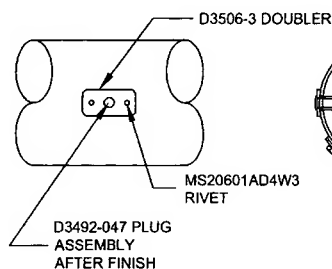
C	ADD D3504-5, FOR SKID GEAR DEFLECTOR; CHANGE FWD CAP BOLT TO AN526C1032-10 SCREW	DC	07.09.19
B	ADD GASKET, CHANGE HARDWARE MAT'L	PH	06.11.01
A	NEW ISSUE	PH	06.04.21
REV.	DESCRIPTION	BY	DATE
DESIGN	PH	DART AEROSPACE USA, INC PORT HADLOCK, WA	
DRAWN	JTC		
CHECKED	PH	DRAWING NO.	REV. C
MFG. APPR.	PH	D3507	SHEET 1 OF 2
APPROVED	PH	TITLE	SCALE
DE APPR.	PH	EC 135 SKIDTUBE	NTS
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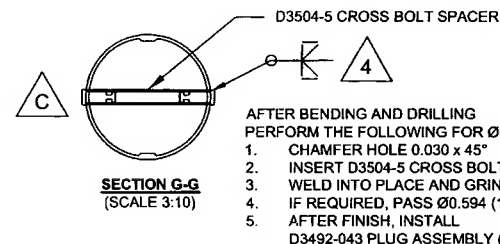
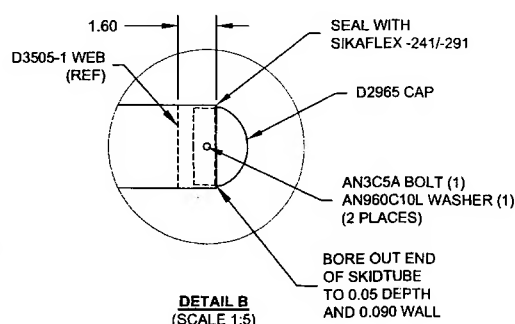
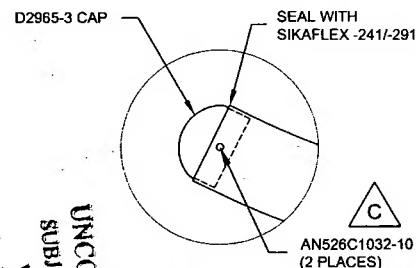
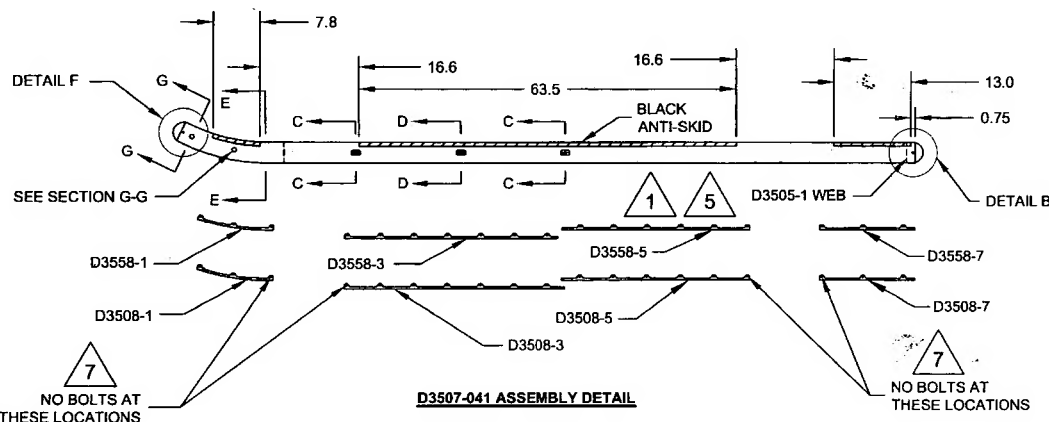
WORK ORDER
41333



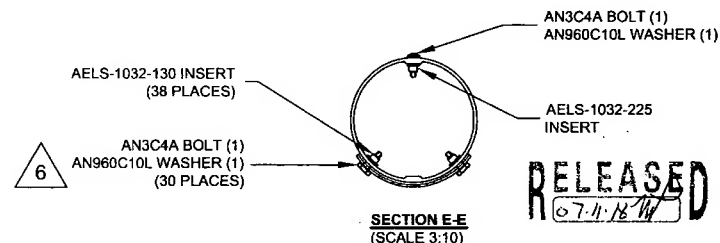
- AFTER BENDING AND DRILLING ASSEMBLY PERFORM THE FOLLOWING FOR Ø0.500 HOLES ONLY:
1. CHAMFER HOLE 0.030 x 45°
 2. INSERT D3504-1 CROSS BOLT SPACER (2 PLACES)
 3. WELD INTO PLACE AND GRIND FLUSH
 4. IF REQUIRED, PASS Ø0.404 (Y" DRILL) THRU HOLE
 5. INSTALL D3506-1 DOUBLER (4 PLACES) USING MS20601AD4W3 RIVET (8 PLACES)
 6. AFTER FINISH, INSTALL D3492-041 PLUG ASSEMBLY (4 PLACES)



- AFTER BENDING AND DRILLING ASSEMBLY PERFORM THE FOLLOWING FOR Ø0.375 HOLES ONLY:
1. CHAMFER HOLE 0.030 x 45°
 2. INSERT D3504-3 CROSS BOLT SPACER (1 PLACES)
 3. WELD INTO PLACE AND GRIND FLUSH
 4. IF REQUIRED, PASS Ø0.277 (J" DRILL) THRU HOLE
 5. INSTALL D3506-3 DOUBLER (2 PLACES) USING MS20601AD4W3 RIVET (4 PLACES)
 6. AFTER FINISH, INSTALL D3492-047 PLUG ASSEMBLY (2 PLACES)



- AFTER BENDING AND DRILLING PERFORM THE FOLLOWING FOR Ø0.750 HOLES ONLY:
1. CHAMFER HOLE 0.030 x 45°
 2. INSERT D3504-5 CROSS BOLT SPACER (2 PLACES)
 3. WELD INTO PLACE AND GRIND FLUSH
 4. IF REQUIRED, PASS Ø0.594 (19/32 DRILL) THRU HOLE
 5. AFTER FINISH, INSTALL D3492-043 PLUG ASSEMBLY (4 PLACES)



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MFG. APPR.	CE	D3507	SHEET 2 OF 2
APPROVED	TH	TITLE	SCALE
DE APPR.		EC 135 SKIDTUBE	1:20
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67-11-11

NO. 179

AWS D17.1.2001
QUALIFICATION TEST RECORD

Name: Barclay Elliot
Job number: B41333
Part number: A135 751011
Description: SKID tube
Welding Process: Tig[☒] Mig[]
Base material: Alum
Current: AC[☒] DC[]

TEST REQUIREMENTS AND RESULTS

Visual: pass[☒] fail[]
Penetration: pass[☒] fail[]

UNACCEPTABLE

Cracks: pass[] fail[]
Undercut: pass[☒] fail[]
Pin holes: pass[☒] fail[]
Overlap (cold lap): pass[] fail[]
Porosity (surface): pass[☒] fail[]
Coloration: pass[☒] fail[]

Qualifier David Lynch Date of Test Coupon 08/10/22

Welder Barclay Elliot Date of Test Coupon 08/10/22

The above named individual is qualified in accordance with AWS D17.1.2001 to weld